

# Work Order ID 50491



Page 1

July 10, 2009 2:41:06 PM

Item ID: D3961-1KIV  
Revision ID: A-PROTO  
Item Name: Rotor Brake Panel

Accept



Setup Start



Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: ME

Date: 09-07-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3961

A-PROTO 09.06.17

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA051 using tool DT9294  
Dwg Rev: A  
Folio Rev: A

BB 09/07/15 x1

M109703

BB 09/07/15 x1



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Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo Visually inspect part for proper formation and texture	0.00  0.00							
									BB 09/07/15 (X1)
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
									Wh. 09/07/16 (X1)
									BB 09/07/16 (X1)
140  Hand Finishing Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg	0.00  0.00							

BB 09-07-09





04/20/78  
A

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Item ID: D3961-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Rotor Brake Panel

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09.07.20 Peronys*

*u 9-07-23  
Pl*





# Picklist Print

Page 1

July 10, 2009 2:41:06 PM

Work Order ID: 50491

Parent Item: D3961-1KIVRevA-PROTO

Parent Item Name: Rotor Brake Panel

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	1.2500			



6185 KYDEX .080"

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	894.5037653	
109703	894.503765	

27<sup>1</sup>/<sub>2</sub> x 21<sup>1</sup>/<sub>2</sub> x 5

M109703

w/o 50500

501

502

503



DART AEROSPACE LTD		Work Order: 50491
Description: ROTOR PRAKE PANEL		Part Number: 03961 -1 KU
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/16

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.3	$\pm 0.3$	.308	✓			
9.3		9.3	✓			
3.2		3.25	✓			
0.045	Mon	0.052	✓			
0.5	$\pm 0.1$	0.52	✓			
0.4	$\pm 0.1$	0.33	✓			
0.125	$\pm 0.001$	0.123	✓			

09.02.12

Measured by: BB

Date: 09/07/16

Audited by: RA

Date: 02.02.12

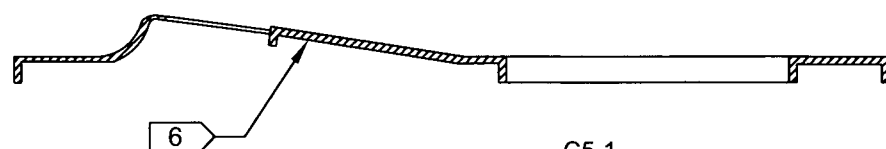
Prototype Approval: RA

Date: 09.02.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

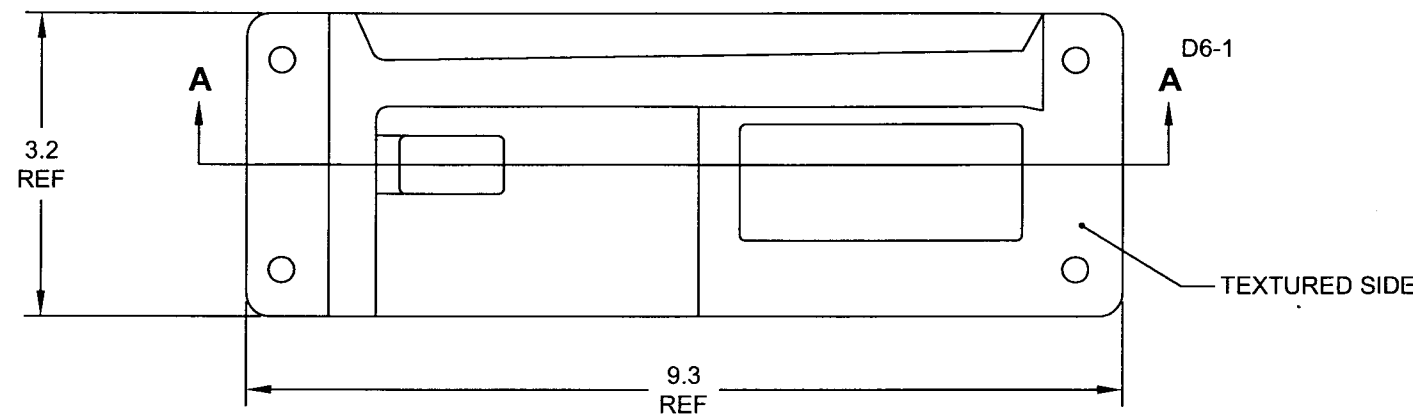
8 7 6 5 4 3 2 1

D

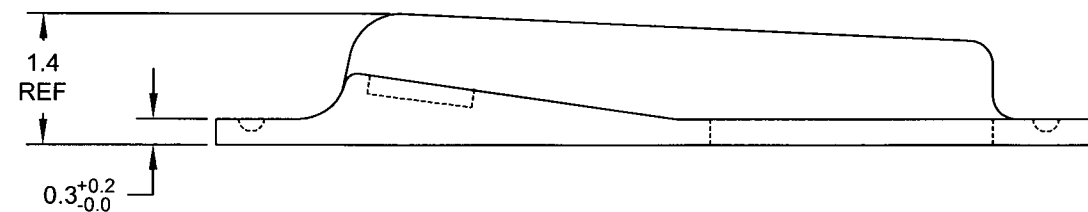


SECTION A-A  
C5-1

C



B



D3961-1 ROTOR BRAKE PANEL

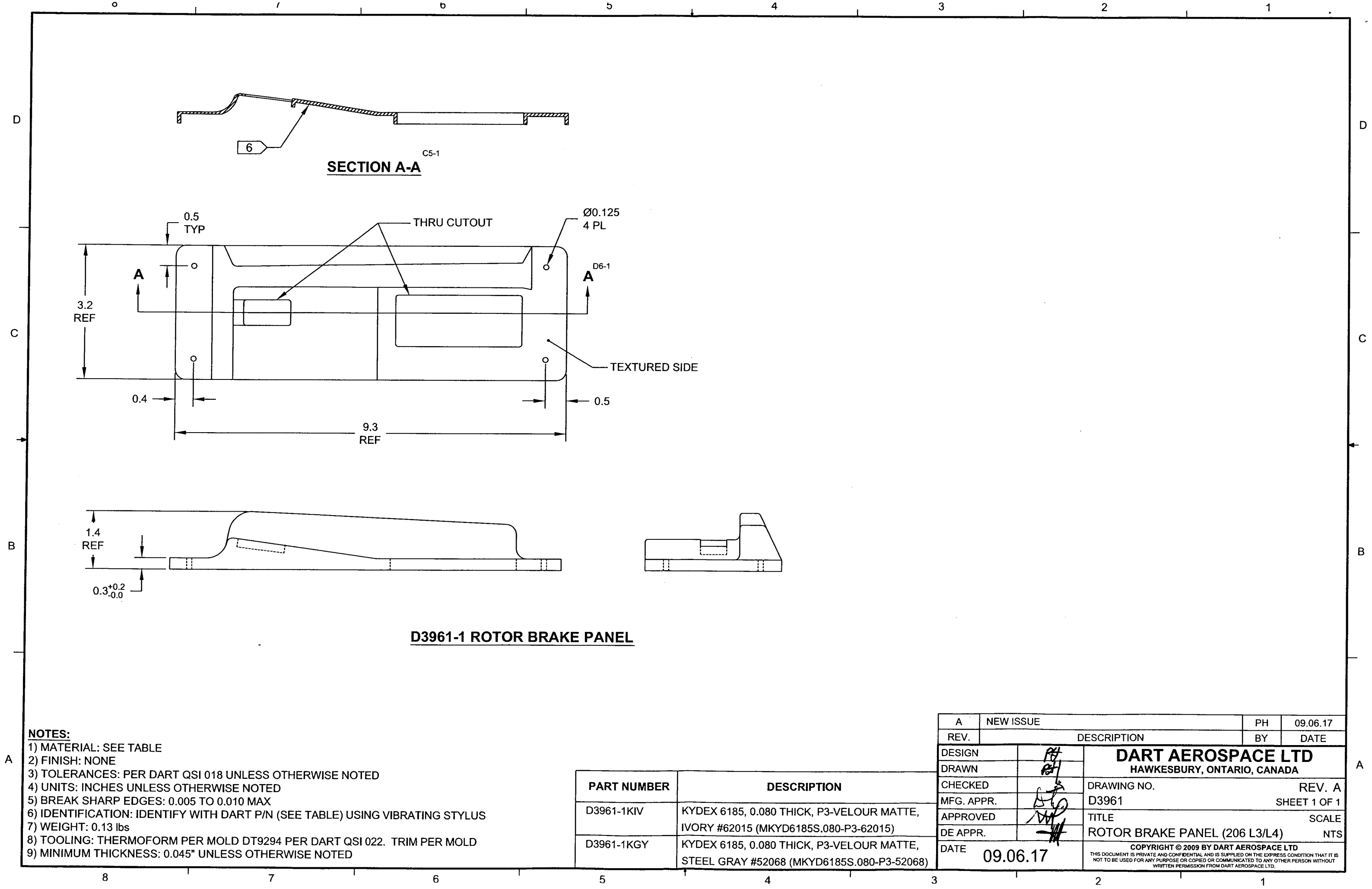
**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.07.07 *PH*

- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 0.13 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9294 PER DART QSI 022. TRIM PER MOLD
  - 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3961-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3961-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.17
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3961	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ROTOR BRAKE PANEL (206 L3/L4)	NTS
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8 7 6 5 4 3 2 1



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  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 0.13 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9294 PER DART QSI 022. TRIM PER MOLD
  - 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3961-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3961-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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